

Work Order ID 79479-1

January-26-12 1:09:25 PM

79479

Page 1

Item ID: D2492

Revision ID:

Item Name: Patient Stop

Start Date: 26/01/2012 Start Qty: -6.00

Required Date: 09/02/2012 Req'd Qty: 6.00

Reference:

Split

Accept

N9000040100

Cust Item ID:

Customer:

Setup Start

Stop

NS1

NS2

Approvals: Process Plan: M.L.J

QC:

Date: 12/01/2012 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start

Stop

NR1

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2492

Rev G

100

100

Waterjet

FLOW CNC Waterjet

6061 .080

FLOW WATER JET

Memo

1-Cut as per Dwg D2492

Dwg Rev: 6

Prog Rev: 6

2-Deburr if necessary

0.00

0.00

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

120

120

QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

Split

B12-2-6

(10)

B12-2-6

(10)



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Page 2

Item ID: D2492

Accept

Revision ID:

N900040100

Item Name: Patient Stop

Setup Start

NS1

Start Date: 26/01/2012 Start Qty: 6.00

6

Stop

NS2

Required Date: 09/02/2012 Req'd Qty: 6.00

6

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Brake NC

Brake NC

NC BRAKE

Memo

Deburr

Form using Jig DT2492B

0.00

0.00

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00



12/27/12



5 φ

12/27-03



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Item ID: D2492

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Patient Stop

Start Date: 26/01/2012 Start Qty: 6.00

6

Required Date: 09/02/2012 Req'd Qty: 6.00

6

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

5X φ

mt
12/07/23

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

170

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:20
3200 F
9:50

5X φ

mt
12/07/23

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

5 φ

BL 12723

ml 21841

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Item ID: D2492

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Patient Stop

Start Date: 26/01/2012 Start Qty: 6.00

6

Required Date: 09/02/2012 Req'd Qty: 6.00

6

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

190

Identify as per dwg & Stock Location: GA

0.00

190

Packaging

Memo

0.00

Packaging

5x 80 12-7-23

200

QC21 - Final Inspection - Work Order Release

0.00

200

QC

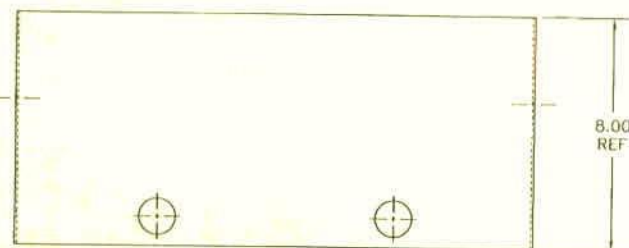
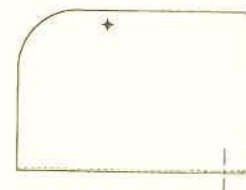
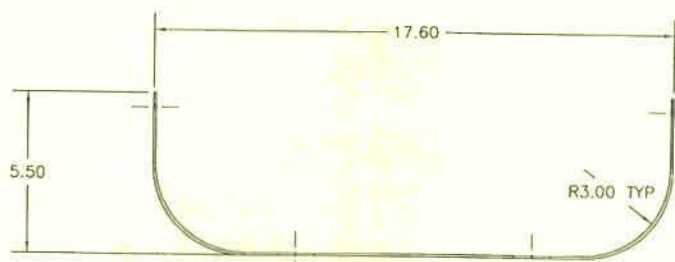
Memo

0.00

Quality Control

12/7/24 *[Signature]*
mf 12-07-23

DART AEROSPACE LTD		Work Order:	79479
Description: Patient Stop		Part Number:	D2492
Inspection Dwg: D2492	Rev: 16. <i>16.12.27</i>		Page 1 of 1



D2492 PATIENT STOP
(MAKE FROM D2492F)

NOTES:

- 1) MATERIAL: MAKE FROM D2492F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D2492" AND B/N PER QSI 044 6.5
- 7) WEIGHT: 1.6 lbs

79479 M.C.J
12/01/26

RELEASED
2010-09-21

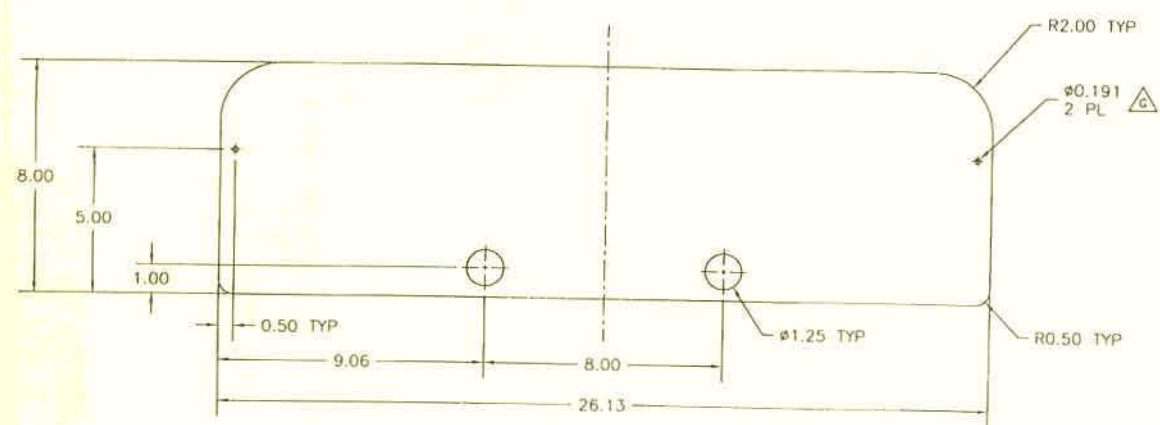
G	REDRAW, ADD FLAT PATTERN, 2 PL WAS 4 PL (ZN C3-2), NCR 10-062	CP	10.08.10
F	Ø1.25 WAS Ø1.020	MB	06.09.14
E	ADD 6061-T6 MAT., R3.0 WAS R4.00, 5.50 WAS 6.00	CB	06.05.30
D	R4.00 WAS R2.00, ADD 8" WIDTH DIM.	KE	98.05.11
C	CHANGES MATERIAL AND FINISH	KE	97.07.14
B	MINOR CHANGES	BW	96.02.28
A	NEW ISSUE	BW	95.10.24
REV	DESCRIPTION	BY	DATE

DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2492 TITLE PATIENT STOP DATE 10.08.10	REV. C
DRAWN	KE		SHEET 1 OF 2
CHECKED	KE		SCALE
MFG. APPR.	KE		NTS
APPROVED	KE		
DE APPR.	KE		

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79479



D2492F FLAT PATTERN

RELEASED
2010-09-30

NOTES:

- 1) MATERIAL: 6061-T6 SHEET 0.080 THICK PER QQ-A-250/11, AMS-QQ-A250/11, AMS 4025, AMS 4027, OR ASTM B209
REF DART SPEC M6061T6S.080
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.6 lbs

DESIGN	KE	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2492	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	PATIENT STOP	NTS
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